



## Product information

# 4CR-Industry 78-120 AY 1K Acrylic Paint semi-gloss/50

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Version 2 / April 2020

### Product description

1K acrylic paint with fast drying and high UV- and weather-resistance for complete and partial coatings on vehicles and machines. Suitable to be filled into aerosol spray cans.

### Dilution

0540-460 Multi Thinner, addition 25 - 30 %

### Spraying viscosity 4 mm DIN

Gravity spray gun 18 - 20 s

### Application method

Application method	Thinner	Pressure	Nozzle
Gravity spray gun	25 - 30 %	1.9 - 2,0 bar	1,2 - 1,3 mm

### Processing conditions

Ensure an adequate supply and exhaust air ventilation. Working temperature must be at least +10 °C. Max. air humidity 80 %.

Spraying operations	DFT	Consumption
Gravity spray gun 2 - 4	30 - 40 µm	9,3 - 12,4 m²/l 9 - 12 m²/kg

### Drying

#### Object temperature 20 °C

Dust free after 10 - 15 minutes  
Set to touch after 20 - 25 hours  
Ready for assembly after 1 - 2 hours  
Recoat after 10- 15 minutes

#### Object temperature 60 °C

Ready for assembly after 30 minutes

Fully cured after 2 days (20 °C).

### Technical specifications

Binder base: acrylic copolymer  
Density DIN EN ISO 2811 (kg/l): 1,0 - 1,2  
Solids content (% by volume): 34 - 37

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Solids content (% by weight): 47 - 53

Delivery viscosity DIN 53211 4 mm (in s): 130 - 150

Gloss level ISO 2813 at 60° (GU): 50 - 60 semi-gloss

Short-term heat resistance: 130 °C

Permanent heat resistance: 70 °C

### VOC regulation

This product contains the following maximum VOC-values: undiluted: < 550 g/l of VOC

### Features

Electrostatic application possible, short drying time, highly UV- and weather-resistant, adhesion on unplasticised PVC.

### Storage

At least 3 years in unopened original container

### Substrate preparation

Remove oil, grease, rust, mill scale, rolling skins, as well as other substances impairing the function of the coating!

Attention: A direct adhesion cannot be taken as granted due to most different kinds of metals, alloys, metallic and conversion coatings and so on. The adhesion must therefore be tested on the original metal substrate.

steel:

blast to cleaning degree Sa 2½, remove blast residues and overcoat promptly

de-rust with hand and power tools to degree of cleanliness St 3

degrease with Anti-Silicone

zincd substrates:

clean the surface with ammonia solution

sweep blast

aluminium:

degrease with 4CR AC Thinner, sand thoroughly with sandpaper P 360/400 and clean subsequently with Anti-Silicone

unplasticised PVC:

clean (remove completely any mould release agents), degrease with plastic cleaner, sand slightly and degrease again with plastic cleaner.

1K old paintworks:

remove completely (sanding, paint remover)



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### Proposed coating

steel:

priming coat: \*43-110 KH Zincphosphate HB Primer with 50 - 60 µm dry film thickness

finishing coat: 78-120 AY 1K Acrylic Paint semi-gloss with 30 - 40 µm dry film thickness

zincd substrates:

priming coat: \*435-110 PVB 1K Etch Primer with 50 - 60 µm dry film thickness

finishing coat: 78-120 AY 1K Acrylic Paint semi-gloss with 30 - 40 µm dry film thickness

aluminium:

priming coat: \*435-110 PVB 1K Etch Primer with 25 - 30 µm dry film thickness

finishing coat: 78-120 AY 1K Acrylic Paint semi-gloss with 30 - 40 µm dry film thickness

unplasticised PVC:

78-120 AY 1K Acrylic Paint semi-gloss with 40 - 50 µm dry film thickness

\*Further 4CR priming coats are available. Please contact your Sales or our Technical staff

### Processing tips

For professional use only.

Especially UV-resistant pigmentations are available on demand.

In case of ambient temperatures higher than 25°C it's necessary to add 70 % of 0540-460 Multi Thinner (to avoid cobwebbing).

Check colour before use.

### Cleaning of tools

Clean tools immediately after use with Nitro-Thinner.